

S246315



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D2423

Job Sheet 205426



Part No: D2423

Job Qty: 104 ft

Part Name: Lug Extrusion



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 1/9/20

Job Tracking No:

Due Date: 1/10/20

Created By: Kimberley Guerin

Type: Stock

Description:

Note: DWG REV B1 IPP G 04.09.02 Part Number D2423-108 changed to D2423 KJ/JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Purchasing - Ft	104 ft		1/10/20	0.00	0.00	Purchasing - 1		
							Purchasing - 2	DAS 81	
							Purchasing - 3	9-89	JAN 10 2020
110	Packaging 2-1 - Receive - B4B	104 pcs		1/10/20	0.00	0.00	Packaging 2 - 1 - B4B	9-89	
							Packaging 2 - 2 - B4B		
							Packaging 2 - 3 - B4B		
							Packaging 2 - 5 - B4B		
							Packaging 2 - 4 - B4B		
							Packaging 2 - 6 - B4B		
							Packaging 2 - 7 - B4B	DAS 81	JAN 10 2020
							Packaging 2 - 8 - B4B	9-89	
							Packaging 2 - 9 - B4B		
							Packaging 2 - 10 - B4B		
							Packaging 2 - 11 - B4B		
							Packaging 2 - 12 - B4B		
							Packaging 2 - 13 - B4B		
							Packaging 2 - 14 - B4B		
							Packaging 2 - 15 - B4B		
							Packaging 2 - 16 - B4B		
							Packaging 2 - 17 - B4B		
							Packaging 2 - 18 - B4B		
							Packaging 2 - 19 - B4B		
							Packaging 2 - 20 - B4B		



Container No: S246315



Part: D2423

Job No: 205426

Serial No/Batch: S246315

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 01/10/20

Plex 1/9/20 3:24 PM Dart.Guerin.Kimberley

					B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
120	QC 6	104 pcs	1/10/20	0.00 0.00	QC 6 - 9	
					QC 6 - 68	DAS
					QC 6 - 61	81
					QC 6 - 40	9-89
					QC 6 - 81	
130	Packaging 3-1 - Stock - B4B	104 pcs	1/10/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	

	Packaging 3 - 17 - B4B				
	Packaging 3 - 18 - B4B				
	Packaging 3 - 19 - B4B				
	Packaging 3 - 20 - B4B				
	Packaging 3 - 21 - B4B				
	Packaging 3 - 22 - B4B				
	Packaging 3 - 23 - B4B				
	Packaging 3 - 24 - B4B				
	Packaging 3 - 25 - B4B				
	Packaging 3 - 26 - B4B				
	Packaging 3 - 27 - B4B				
	Packaging 3 - 28 - B4B				
	Packaging 3 - 29 - B4B				
	Packaging 3 - 30 - B4B				
	Packaging 3 - 31 - B4B				
	Packaging 3 - 32 - B4B				
	Packaging 3 - 33 - B4B				
	Packaging 3 - 34 - B4B				
	Packaging 3 - 35 - B4B				
	Packaging 3 - 36 - B4B	JAN 13 2020			
	Packaging 3 - 37 - B4B	DAS 21 9:59			
140 QC 21 - SA FT	104 ft	1/10/20	0.00 0.00	QC 21 - SA - 21	DAS 21 9:59
				QC 21 - SA - 70	JAN 13 2020
				QC 21 - SA - 53	DAS 21 9:59

Part Op 100 - (Purchasing) Issue P/O: _____ Manufacture as per Dwg Possible Supplier: SIGNATURE
 Descriptions: ALUMINUM

- 110 - (Receive & Inspect for Damage & Mat'l Certs)
- 120 - (QC6- All purchased or subcontracted products)
- 130 - (Identify as per dwg & Stock Location: _____)
- 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2423P	Lug Extrusion	104 ft (1 ea)	100-Purchasing - Ft	5246305

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing - Ft	D2423P	104	0	0

Part Specifications

Specifications could not be found.

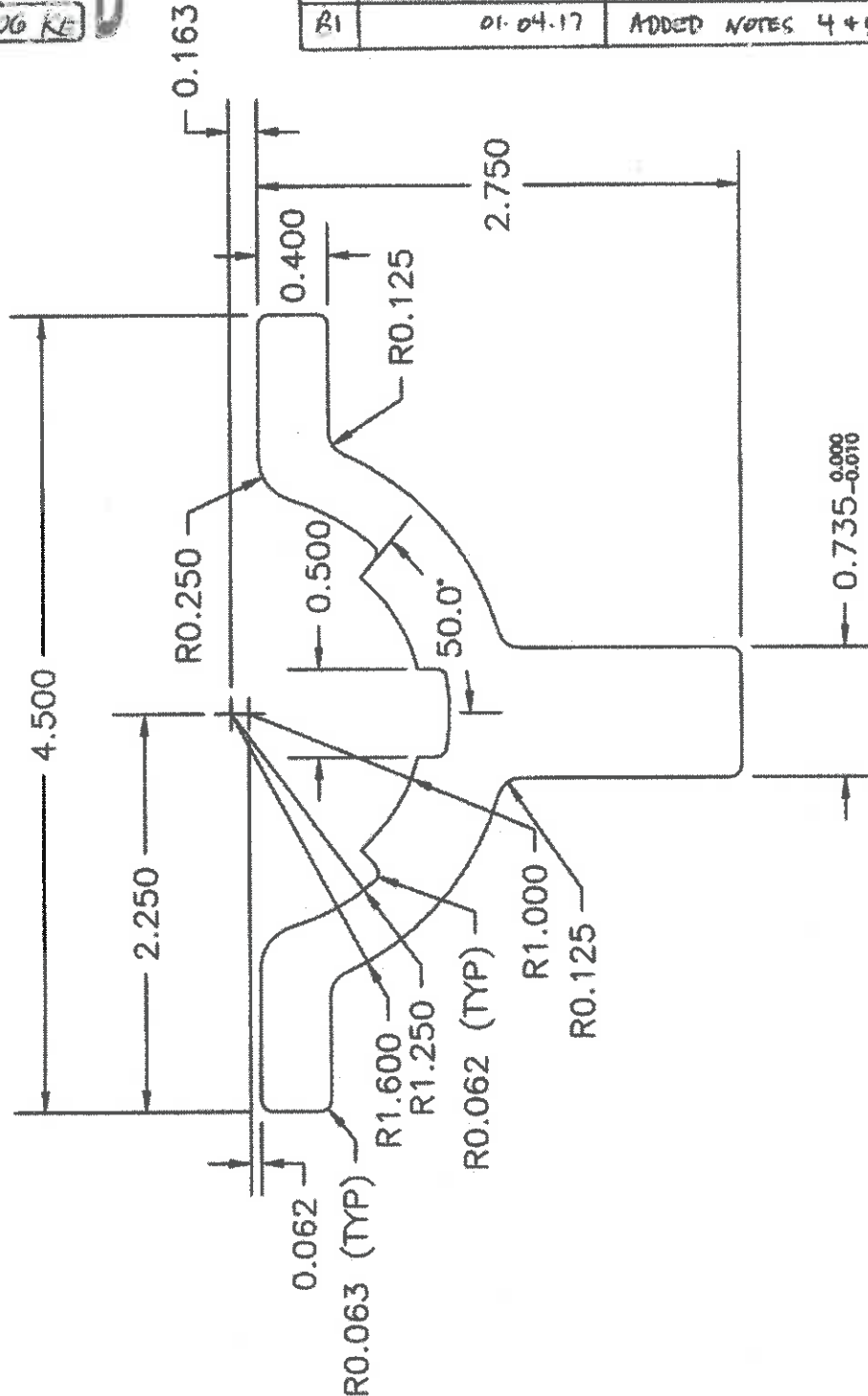
Plex 1/9/20 3:24 PM Dart.Guerin.Kimberley

DART



RELEASED
99/04/06 KE

DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2423	REV. B SHEET 1 OF 1
DATE 98.08.04		TITLE LUG EXTRUSION	SCALE 1:1
A	95.05.09	NEW ISSUE	
B	98.08.04	6061-T6 WAS 6005A.T5	
B1	01.04.17	ADDED NOTES 4 + 5 # CP	



1. MATERIAL: 6061-T6 ALUMINUM (QQ-A-200/8)

2. NOTE: ALL DIMENSIONS ARE IN INCHES

3. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4. MANUFACTURED USING CARBON WHEELS DE # M5-12826

5. PART NUMBER: D2423-108 WHERE XXX IS CUT LENGTH IN INCHES (EG. D2423-108 IS 108" LONG)

Line 2
D2423



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044949



Supplier: SIG001-VC
Signature Aluminum Canada Inc.
C/O/ T10322C
PO Box 4488, STN A
TORONTO
ON
M5W 4H1 Canada
Phone: 905-427-6550
Fax: 905-427-2246

PO No: POHB044949
PO Date: 10/30/19
Due Date: 12/20/19
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	202547	D2622-120CP	D2962 Rev C		Extrusion : EXTRUDE AS PER DWG D2622-120 REV. C DIE # DAA- 897123 LENGHT 120" EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF TUBE MATERIAL MUST BE SMOOTH AND FREE FROM DEFECT SCRATCHES,NICKS,DENTS	Received	-	12/20/19	163 pcs	163 pcs	0 pcs	\$25.2487/pcs	\$0.00
2	202743	D2423P	D2423 Rev B1		Lug Extrusion : AS PER DWG D2423 REV. B (EXTRUSION CUT AT 8 FT LONG) die # DAA-5-2 EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE OUTSIDE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,NICKS,OR DENTS	Partial	-	12/20/19	208 ft	208 ft 208 ft vm	208 ft	\$10.3178/ft	\$2,146.10



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PURCHASE ORDER

POHB044949



Items

Line Item	Job	Part	Drawing	Supplier Part No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	205426	D2423P	D2423 Rev B1		Lug Extrusion : AS PER DWG D2423 REV. B (EXTRUSION CUT AT 8 FT LONG) die # DAA-5-2 EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE OUTSIDE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES,NICKS,OR DENTS	Firmed	-	1/9/20	104 ft	0 ft 104 ft rm	104 ft	\$10.3178/ft	\$1,073.05
JAN 10 2020													

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Handwritten signature: H. Guerin

Plex 1/9/20 3:25 PM Dart.Guerin.Kimberley

Carrier: RS-BYFORD/CANUS

Shippers No: 046208



TRL T35

From: SIGNATURE ALUMINUM CANADA

on 01/07/20

1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

ISSUED AT SHIPPER'S REQUEST

ÉMIS À LA DEMANDE DE L'EXPÉDITEUR

Received, subject to the classifications and tariffs in effect on the date of issue of this Original Bill of Lading, or, received, subject to the Rules for the Carriage of Express and Non-Carload Freight Traffic and tariffs in effect on the date of issue of this Original Shipping Contract (Bill of Lading), goods described below, in apparent good order, except as noted (contents and conditions of contents of packages unknown), marked, consigned and defined as indicated below, which said Company, agrees to carry to its usual place of delivery at said destination, if on its road, otherwise to deliver to another carrier on the route to said destination. It is mutually agreed, as to each carrier of all or any of said goods over all or any portion of said route to destination, and as to each party at any time interested in all or any of said goods, that every service to be performed thereunder shall be subject to all the terms and conditions (which are hereby incorporated by reference and have the same force and effect as if the same were severally, fully and specifically set forth herein):

1. Railway Traffic Liability Regulations (207/91-489 August 14, 1991) passage of the National Transportation Act, 1987.
2. of the Bill of Lading of the water carrier as provided in its tariffs and Regulations when said goods are carried by a water carrier; or
3. of the Bill of Lading of the motor carrier as provided in its tariffs, conditions, statutes and regulations pertaining to motor carrier's services when said goods are carried throughout by a motor carrier; or
4. of the Bill of Lading in Schedule 2 by O.C. 47-69 of January 13, 1988 when said goods originating in Quebec are to be carried by a motor carrier.
5. or approved by the Board of Transport Commissioners for Canada by General Order No. T-43, set forth in the Rules for the Carriage of Express and Non-Carload Freight Traffic and also available at all express and railway agency stations and express and freight offices upon request, when said goods are carried by a rail carrier, and which are agreed to by the shipper and accepted for himself and his assigns.

Reçu, sous réserve des classifications et tarifs en vigueur à la date de livraison de ce connaissement original, ou sous réserve des règlements régissant le transport des marchandises et marchandises de détail et des tarifs en vigueur à la date de livraison de ce contrat de transport (connaissement), les marchandises désignées ci-dessous, apparement en bon état, sauf les remarques contenues aux présentes (le contenu et l'état du contenu des colis étant inconnus), marquées et consignées tel que ci-après indiqué, et que la Compagnie s'engage à transporter à destination à son lieu habituel de livraison, pourvu que l'adresse destination soit sur son parcours, d'abord à les livrer à un autre voiturier faisant route vers cette destination. Il est ci plus convenu que tout voiturier transportant tout ou partie desdites marchandises sur tout ou partie du parcours, que ce soit une personne intéressée en aucun temps à tout ou partie desdites marchandises et que tous services prévus aux présentes seront assurés à toutes les conditions (jusqu'à ce, par exemple, sont intégrées aux présentes et ont la même force et le même effet que si elles étaient ci-dessous séparément, et intégralement et expressément):

1. Le Règlement sur la responsabilité à l'égard du transport ferroviaire de marchandises (LORS/91-489, 14 août 1991) adoptée en vertu de la loi de 1987 sur les transports nationaux.
2. du connaissement du transporteur maritime, conformément aux dispositions et règlements énoncés dans les tarifs s'appliquant au transport par eau; ou
3. du connaissement prescrit par les tarifs, conditions, statuts et règlements se rapportant à un service de camionnage si lesdites marchandises sont transportées par camion; ou
4. du connaissement selon l'annexe 2 du Décret 47-69 du 13 janvier 1988, si les marchandises sont expédiées de la province de Québec par camion.
5. approuvées par l'ordonnance générale No. T-43 de la Commission Canadienne des Transports pour le Canada régissant le transport des marchandises et marchandises de détail et dont le texte peut être obtenu sur demande à toutes les gares de voyageurs et de marchandises, ainsi qu'à tous les dépôts de marchandises si lesdites marchandises sont transportées par un voiturier du rail, conformément auxquelles l'expéditeur consent et qui s'accepte pour lui-même et ses ayants droit.

Consigned To: DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
CANADA

S/O: 138199
Freight: Prepaid

*** MUST SEND PICTURES WITH ASN***

HZHAO@DARTAERO.COM

kguerin@dartaero.com

No		LTl	Haz				
Pkgs	Description Of Articles	Cls	Mat	Net	Tare	Gross	
1	Aluminum Lineal Shapes; Item 13515-A	60		388 lbs 176 kgs	11 lbs 5 kgs	399 lbs 181 kgs	

RECEIVED

JAN 08 2020

DART AEROSPACE LTD.

1	TOTAL	388 lbs 176 kgs	11 lbs 5 kgs	399 lbs 181 kgs
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Shipper, Per R1CZARKO
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W 3R8

CANADA

CARRIER / AGENT RS BYFORD				CONSIGNEE / CONSIGNATAIRE			
DATE	D/J	M/M	Y/A	DATE	D/J	M/M	Y/A
	07	01	20				
PER / PAR				PER / PAR			

Visit us at www.signaturealum.com



1850 Clements Road, Pickering Ontario, Canada L1W 3R8
Phone: (905) 587-5780 Fax: (905) 427-2207
Visit us at www.signaturealuminum.com

INVOICING AND COMPANY LOCATION
SIGNATURE ALUMINUM CANADA
1850 CLEMENTS ROAD
PICKERING ON L1W.3R8

PACKING LIST

PACKING LIST DATE / DATE DU BODEREAU	01-07-20
PACKING LIST NUMBER / N° DE BODEREAU	046208
SALES ORDER NUMBER / N° DE COM	138199

REFER TO
THESE NUMBERS ON
ALL CORRESPONDANCE
REFEREZ-VOUS A CES
NUMEROS POUR TOUTE
CORRESPONDANCE

TERMS / FREIGHT
PP

ACCT# 46024

SHIP TO / EXPÉDIÉ A DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200		SOLD TO / VENDUE A DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA PHONE: 613-632-5200	
--	--	---	--

CUSTOMER ID / ID DU CLIENT	46024	ORDER DATE / DE LA COM	11/01/19	CUSTOMER PO NUMBER / CLIENT PO Nombre	POHB044949	BILL OF LADING NUMBER / NO. DE CONNAISSANCEMENT		046208								
ORIGINAL ORDER QUANTITY / Quantité d'ordre ORIGINAL	UNIT / UNITE	PREVIOUS SHIPPED QUANTITY / PRECEDENT Quantités livrées	MFG. PART NUMBER / MFG. PARTIE NUMÉRO	ALLOY & TEMPER / ALLIAGE & TEMPER	LENGTH / LONGUEUR	CUTTING TOLERANCE / Tolerances de coupe	CUSTOMER PART NUMBER / NUMERO DE REFERENCE DU CLIENT	FINISH DESCRIPTION / DESCRIPTION DE FINITION	FABRICATION DESCRIPTION / DESCRIPTION DE FABRICATION	SHIPPING TOLERANCE / EXPÉDITION TOLERANCE	NBR OF PKGS / NBR DE PKGS	GROSS LBS / LIVRES BRUT	NET QUANTITY / QUANTITÉ NETTE	UNIT / UNITE	QUANTITY DUE / Quantité en raison	
002	1,109 LB		DAA-5-2	96.0000 IN	6061 T6						1	399	388	LB		
Y	503 KG		D2423P									181	176	KG		
	36 PC			Cut (+): 0.1180									13	PC		
				Cut (-): 0.0000												
											912028	521419	1	399	388	13 PC

DAS
82
9-89

13 Pcs / 104 Pk
REC.

JAN 08 2020

Page 1 of 1

Transportation/Traffic damages and/or shortage claims are to be noted on the delivery copy of sellers shipping packing lists and signed and dated below by customers authorized representatives. No return materials will be accepted for credit without permission. The articles and/or services covered by this shipping packing list were produced in accordance with the fair labor standards act of 1938 as amended. Order accepted subject to the terms and conditions stated on our website.

1	399	388	LB
	181	176	KG
		13	PC
TOTALS			

ACKNOWLEDGEMENT OF GOODS DELIVERED AND CONDITION

DATE OF DELIVERY

DRIVER

**SIGNATURE ALUMINUM CANADA**1850 CLEMENTS RD
PICKERING, ON L1W 3R8**CERTIFICATE OF COMPLIANCE**

2

Cert Date	Cert No.	Sales Order	Page
12/18/2018	5511215	138199	1
Cust PO	B/L No.	Lot	Date
POHB044949	046208	912028 <i>hkt</i>	01/07/20

Sold To	Ship To
46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA	46024 DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 CANADA

Item No	Part No	Item Description	Cust Part
002	DAA-5-2	8 MILL 6061 T6	D2423P
Gross Weight	399 LBS		
Net Qty	388 LBS	13 PCS	1 PKG
Specification	AMS QQA 200/8 + ASTM B221	<i>DAS</i> 82 9-89 JAN 0 8 2020	Die Desc

Mechanical Tests:

<u>Tensile</u>	<u>Yield</u>			
<u>MPA / KSI</u>	<u>MPA / KSI</u>	<u>% Elongation</u>	<u>Conductivity</u>	<u>HRE</u>
284.2 / 41.2	248.3 / 36.0	11.8	N/A	92

Chemical Analysis:

<u>Si</u>	<u>Fe</u>	<u>Cu</u>	<u>Mn</u>	<u>Mg</u>	<u>Cr</u>	<u>Zn</u>	<u>Ti</u>	<u>V</u>	<u>Zr</u>
0.62	0.27	0.22	0.06	0.91	0.07	0.04	0.01	0.01	0.00

RECEIVED**JAN 0 8 2020****DART AEROSPACE LTD.***This Material is Made in Canada**This Material is RoHS Compliant*

This will certify that the material described herein has been inspected and tested in accordance with Signature Aluminum Canada's standard sampling and testing procedures or in accordance with the requirements of any specification forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

S. Gooder
Quality Manager
Signature Aluminum Canada Inc

ISO 9001/TS16949 Registered Company

Visit us at www.signaturealum.com

Rev A

2

MATERIAL RECEIPT INSPECTION FORM

MATERIAL: D2423
DATE: ~~0707-01~~ JAN 10 2020

PO / BATCH NO.: POHBO44449 / S246305

MATERIAL CERT REC'D: Yes
QUANTITY RECEIVED: 104ft
QUANTITY INSPECTED: 104ft
QUANTITY REJECTED: _____

THICKNESS ORDERED: _____
THICKNESS RECEIVED: _____
SHEET SIZE ORDERED: _____
SHEET SIZE RECEIVED: _____

DESCRIPTION	NCR (Check Y/N)	COMMENTS
SURFACE DAMAGE	Y ☒ N	
CORRECT FINISH	☒ Y N	
CORROSION	Y ☒ N	
CORRECT GRAIN DIRECTION	☒ Y N	
CORRECT MATERIAL PER M-DRAWING	☒ Y N	AMS QQ-A-200/8
CORRECT THICKNESS	☒ Y N	
PHOTO REQUIRED	Y ☒ N	
CORRECT REF # TO LINK CERT	☒ Y N	HT: 912028
CORRECT MATERIAL IDENTIFICATION	☒ Y N	
CORRECT M# ON THE MATERIAL	☒ Y N	
DOES THIS MATERIAL REQUIRE ENGINEERING SIGN OFF	Y ☒ N	
DOES THIS REQUIRE AN EXTRUSION REPORT	Y ☒ N	

CUT SAMPLE PIECE OF MATERIAL AND PREFORM A HARDNESS CHECK. RECORD RESULTS BELOW					
TYPE OF MATERIAL	HRC	HRB	DUR A	DUR D	WEBSTER
SIZE OF TEST SAMPLE					
HARDNESS / DUROMETER READING					

testers located in the Quality Office

QC 18 INSPECTION	ENGINEERING SIGNOFF (if required)
INSPECTED BY: _____ DATE: <u>JAN 10 2020</u>	SIGNED OFF BY: _____ DATE: _____

DAS
81
9-89

Attach this inspection sheet with the corresponding material cert and remit to be scanned and received in